

Work Order ID 131073

March-26-15 1:40:04 PM

131073

Page 1

Item ID: D4073-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Hinge
 Start Date: 3/23/15 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-03-27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4073	B

100	Cut blanks as per folio	0.00				20	Ø		DAS 20 9-89 15-04-01
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	cut blank 4.563" long								

105		0.00				20	Ø		DAS 20 9-89 15-04-01
105									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg an Folio FA939								
	Dwg Rev: <u>B</u>								
	Folio Rev: <u>AA</u>								

Debur

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>20</u>	<u>Ø</u>		DA. 20 15-04-01 9-89
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		M.O 15/04/06		<u>20</u>	<u>Ø</u>		DAS 08 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>20</u>	<u>Ø</u>	<u>15-4-17</u>	<u>Del</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>N 131545</i> Memo	0.00 0.00				20	0	15-4-21	<i>START: 1:00</i> <i>OVER, T: 320°</i> <i>FINISH: 1:30</i> 20 3 08
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				20X		DAS 28 9-89	APR 22 2015 DAS 30 9-89
180 *180* Packaging Packaging	Identify as per dwg & Stock Location <i>st 085</i> Memo	0.00 0.00				20		DAS 27 9-89	APR 22 2015

APR 22 2015

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-23
MF
15-4-23

DQA: _____ Date: _____

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Picklist Print

March-26-15 1:40:04 PM

Page 1

Work Order ID: 131073

131073

Parent Item: D4073-1

D4073-1

Parent Item Name: Door Hinge

Start Date: 3/23/15

Required Date: 3/26/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2000X0125 0		Purchased	No			100	f	29.8560	0.38	8			

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

**

8.333'

DAS

20

9-89 1504-01

Location

Loc Qty

Loc Code

MAT003

29.856

M128247

20

M128436

3

M129375

6.856

3.750'

M6061T6 200X1.500

M128247

4.583'

DQA: _____ Date: _____



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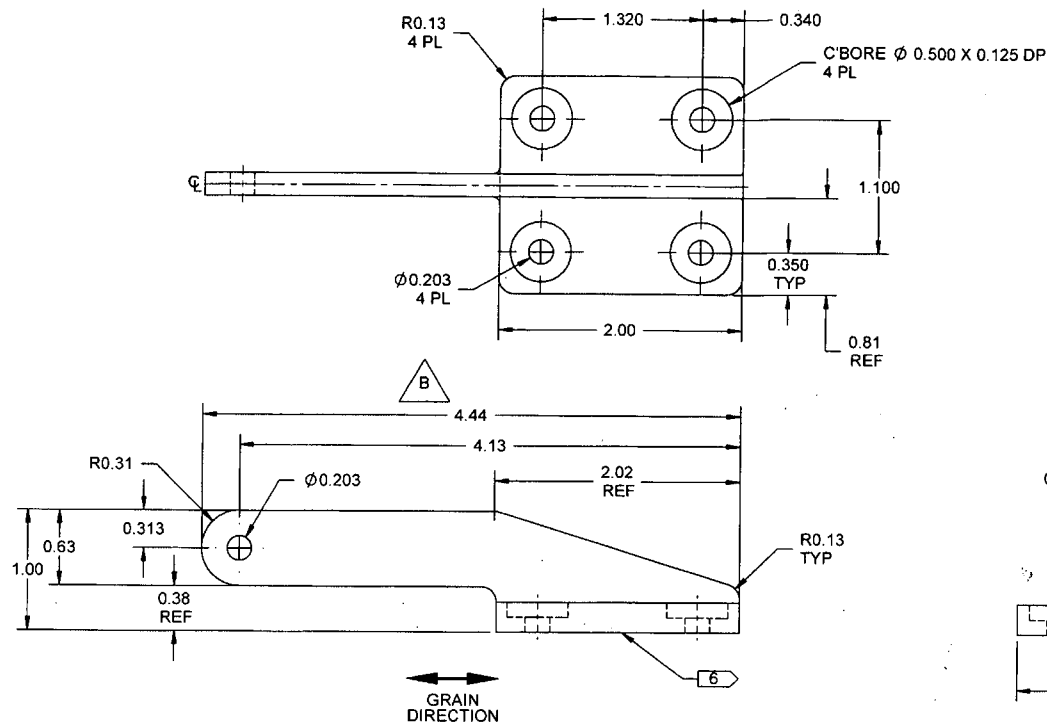
DART AEROSPACE LTD		Work Order: 131073
Description: Door Hinge		Part Number: D4073-1
Inspection Dwg: D4073	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	+/-0.030	.125	✓		Rad gauge	
Ø0.203	+0.005/-0.001	.204	✓		gauge Pin	
2.00	+/-0.030	2.000	✓		SL08 Vern	
0.81	+/-0.030	.805	✓		"	
0.350	+/-0.010	.348	✓		"	
1.100	+/-0.010	1.100	✓		"	
Ø0.500 x 0.125	+/-0.010	.504 x .126	✓		"	
0.340	+/-0.010	.337	✓		"	
1.320	+/-0.010	1.321	✓		"	
4.44	+/-0.030	4.438	✓		Height gauge	
4.13	+/-0.030	4.126	✓		"	
R0.31	+/-0.030	.310	✓		Rad gauge	
0.313	+/-0.010	.309	✓		SL08	
0.63	+/-0.030	.625	✓		"	
1.00	+/-0.030	1.004	✓		Height gauge	
0.38	+/-0.030	.3755	✓		"	
0.190	+/-0.010	.192	✓		SL08	
1.80	+/-0.030	1.801	✓		↓	
0.25	+/-0.030	.250	✓			
R0.13	+/-0.030	.125	✓		↓ Rad gauge	

Measured by: DAS 20 9-89	Audited by: DAS 08 9-89	Preliminary Approval:
Date: 15-04-01	Date: 15/04/06	Date:

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	



D4073-1 DOOR HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

B	4.44 WAS 3.75; 4.13 WAS 3.44 (ZN C6-1)	RF	11.05.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.05.02		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

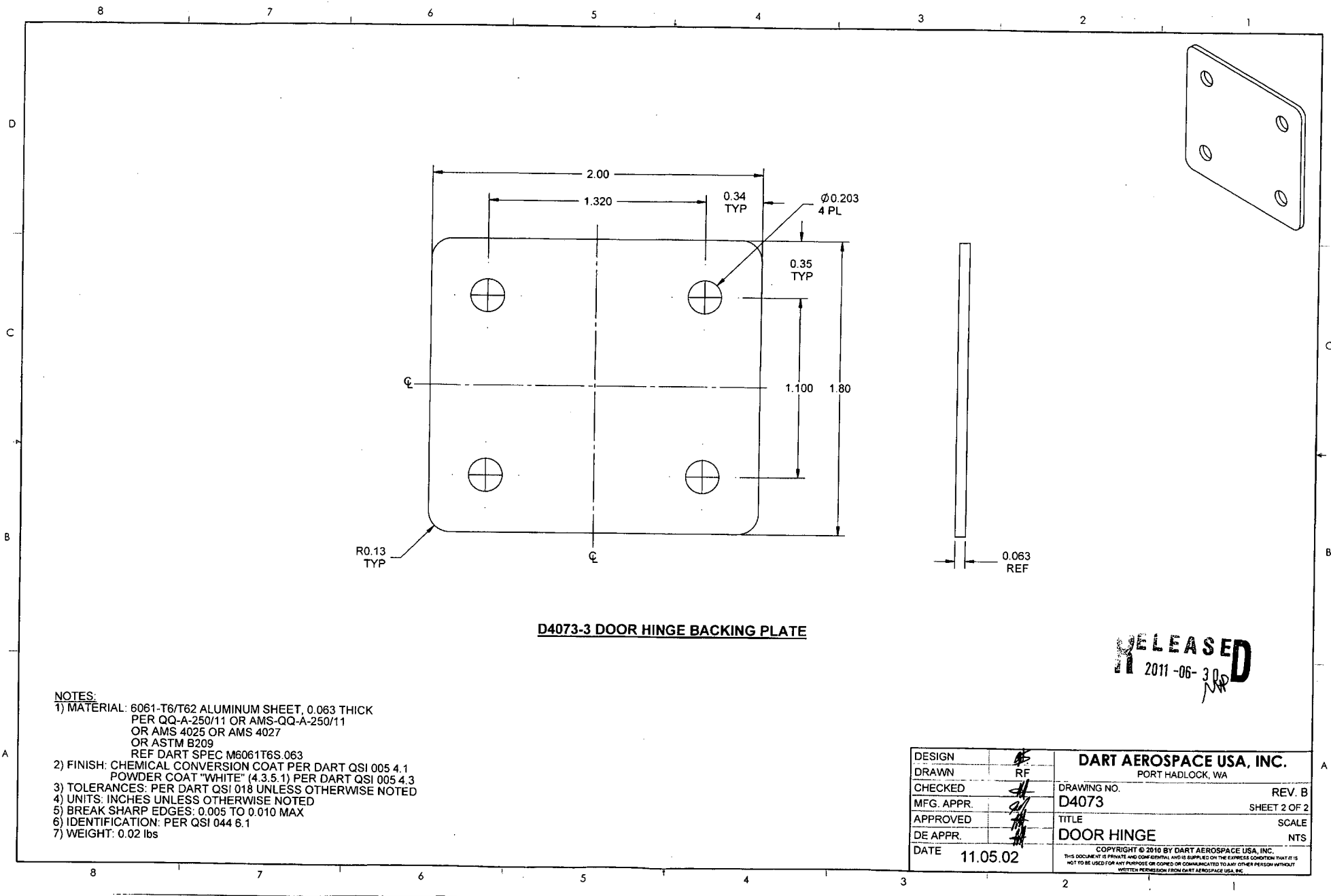
DRAWING NO. **D4073** REV. B
SHEET 1 OF 2

TITLE **DOOR HINGE** SCALE NTS

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2011-06-30
MD

NO 131073 MLJ
15-03-27



D4073-3 DOOR HINGE BACKING PLATE

- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

RELEASED
2011-06-30
NRP

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4073	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOOR HINGE	NTS
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